

NEXT RELEASE

Dart Aerospace Ltd.

Date: Wednesday, 23/07/2008 12:49:34 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING PLATE
Job Number : 40722
Estimate Number : 12408
P.O. Number : Part Number : D34992
This Issue : 23/07/2008 S.O. No. : Drawing Number : D3499 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : SMALL /MED FAB Drawing Revision : B
Previous Run : 28486 Material :
Written By : Due Date : 28/07/2008 Qty: 8 Um: Each
Checked & Approved By : JLD 08-7-23
Comment : Est Rev: A New Issue 06-05-05 JLM
Est Rev: B As per Rev B 06-08-31 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 1.1214 sf(s)/Unit Total: 8.9712 sf(s)
6061-T6 .125 Sheet
(M6061T6S0125)
Batch: 106634 FB 8-7-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3499
Dwg Rev: B
Prog Rev: B

FB 8-7-23



2-Deburr if necessary FB 8-7-23

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

FB 8-7-23

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/07/24



5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary.

Done at step 4 22

S 08/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: MOUNTING PLATE	
Job Number: 40722		Part Number: D34992	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Bend as per Dwg D3499			
7.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			
9.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3			
START TIME: 8:50 OVEN TEMPERATURE: 320 °C FINISH TIME: 9:20			
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION			
11.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 506			
12.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE			
Job Completion			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

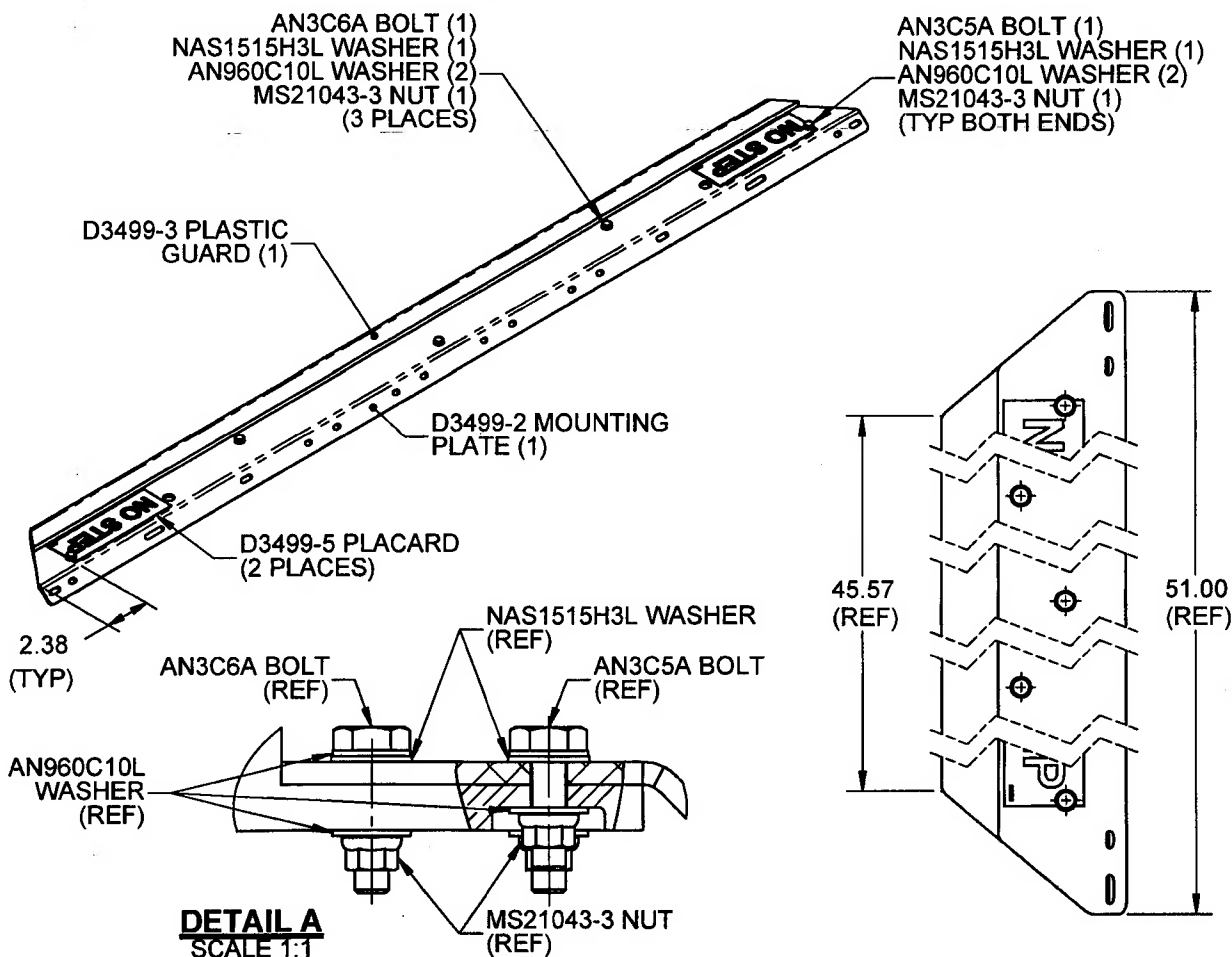
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

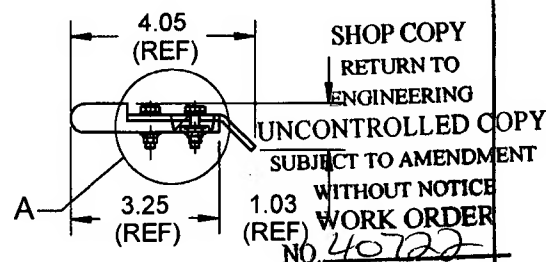


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 1 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4
A	06.04.11	NEW ISSUE	
B	06.08.15	RE-DESIGN D3499-2F/-3	



D3499-042 CABLE GUARD ASSEMBLY

QTY -042	P/N	DESCRIPTION
X	D3499-042	CABLE GUARD ASSEMBLY
1	D3499-2	MOUNTING PLATE
1	D3499-3	PLASTIC GUARD
2	D3499-5	PLACARD
2	AN3C5A	BOLT
3	AN3C6A	BOLT
10	AN960C10L	WASHER
5	MS21043-3	NUT
5	NAS1515H3L	WASHER

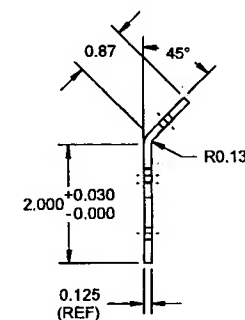
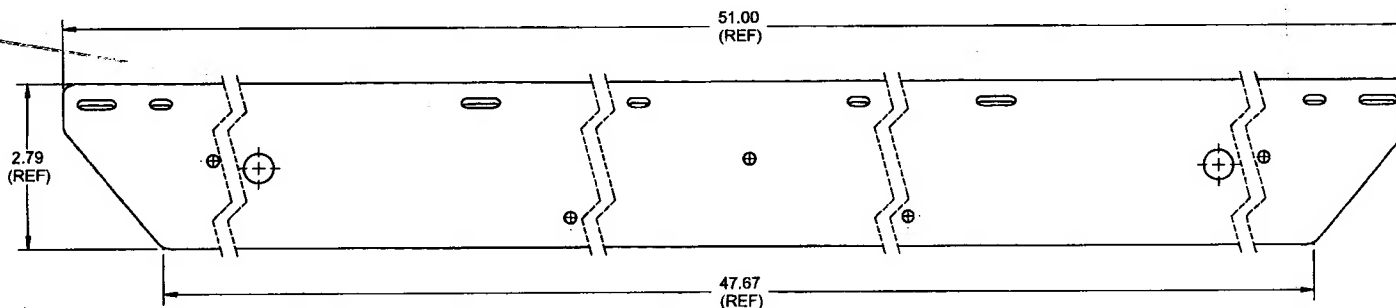
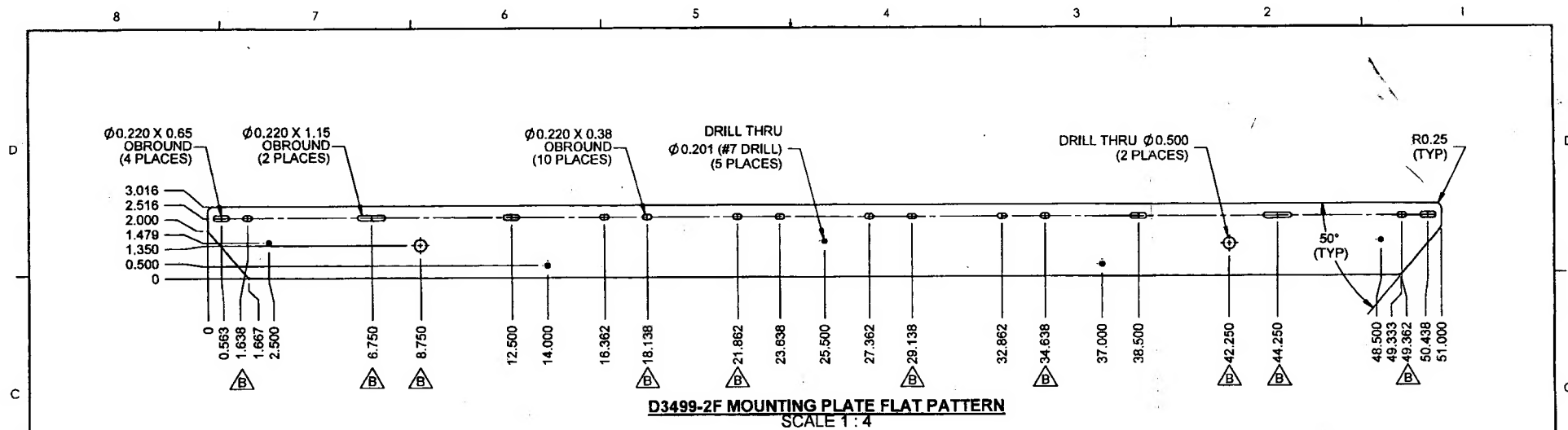


NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTES:

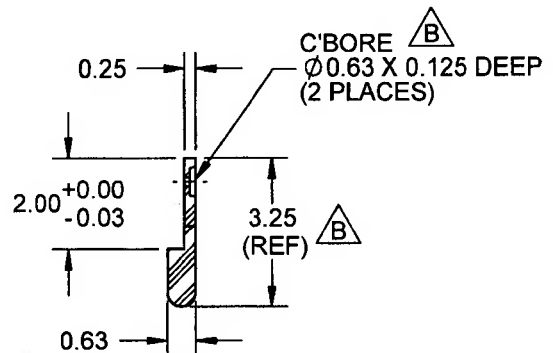
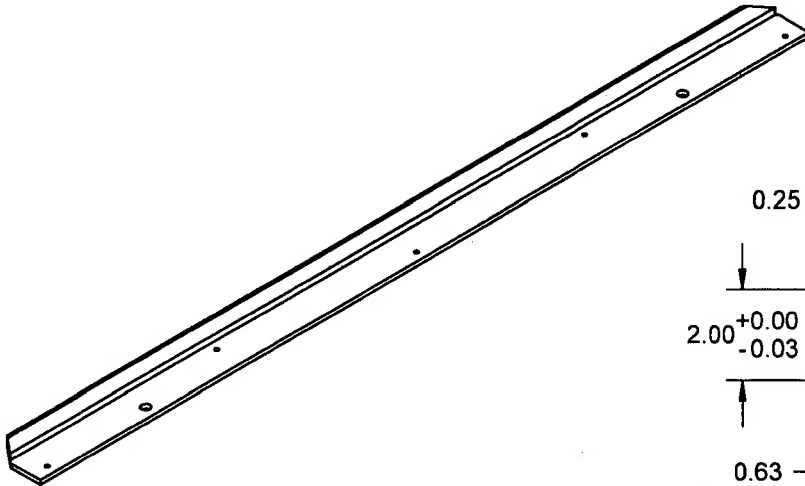
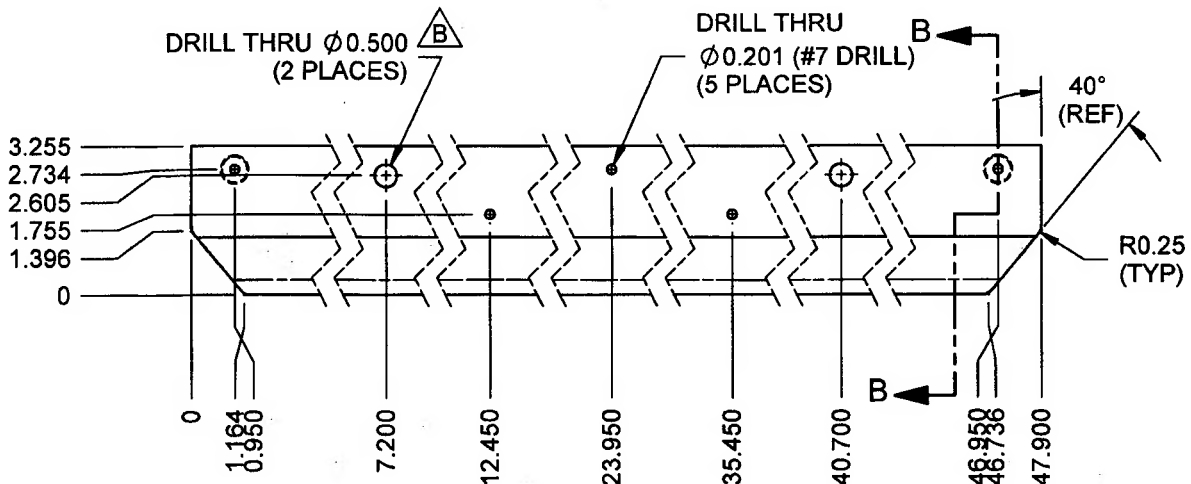
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1.
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

NO. 40722
WORK ORDER
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CHECKED PH	APPROVED B	DRAWING NO. D3499	REV. B SHEET 2 OF 4
DATE 06.08.15	TITLE CABLE GUARD	SCALE 1:2	
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DATE 06.08.15	TITLE CABLE GUARD		SCALE 1:4

**SECTION B-B****D3499-3 CABLE GUARD****NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

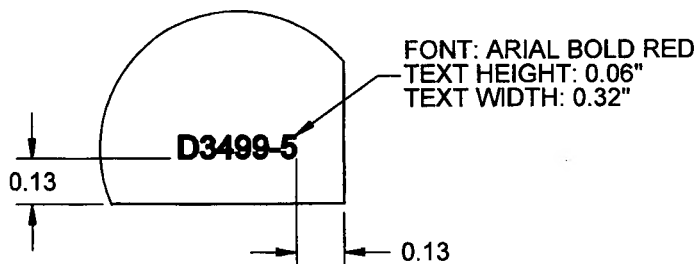
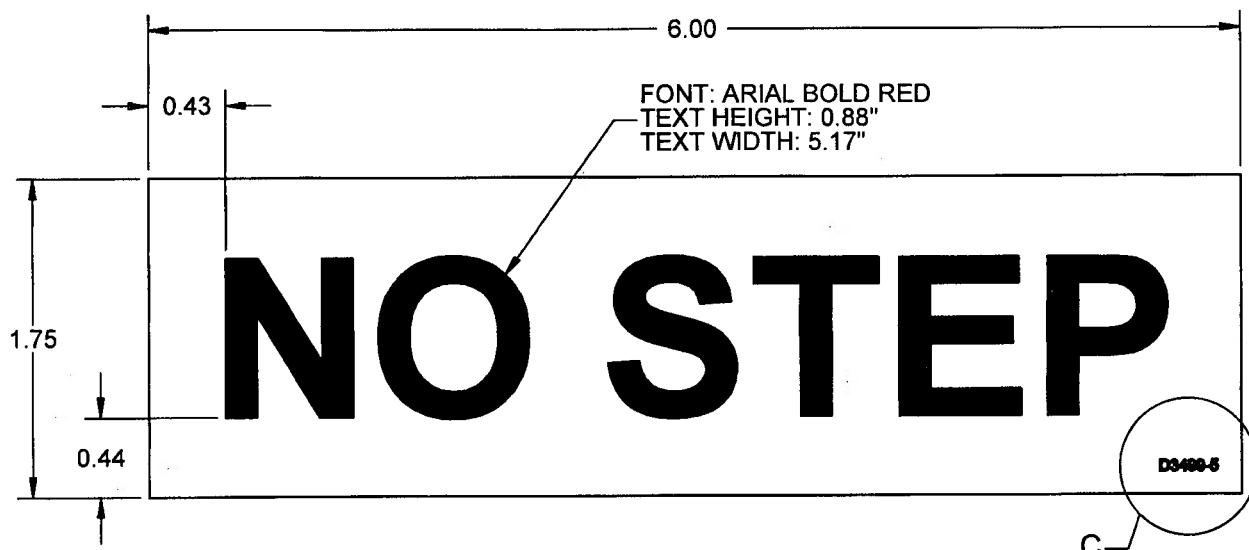
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DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:1



DETAIL C
SCALE 1:2

D3499-5 PLACARD

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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